Work Order ID 115596

115596

April-04-14 10:14:14 AM

Item ID: D3298-001 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Tube Assembly

Start Date: 4/04/14 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 4/04/14 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MC5 **Date:** 14-04-04 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3298	Rev B								
100	Small Fab	0.00				4		FF 14-02-10	
100									
Small Fab	**Memo**	0.00							
Small Fab	Bend tube as per template D3298-001T1 & Dwg D3298Flare end as per Dwg D3298.Ensure that sleeves and coupling are installed first DAS 27 9-89								
110	QC5- Inspect part completeness to step on W/O	0.00				4			
110									
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: ST219	0.00				4X		~~14-11-7~~ 14-7-11 DAS 26 9-89	
120									
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

April-04-14 10:14:13 AM

Work Order ID: 115596 *115596*

Parent Item: D3298-001 *D3298-001*

Parent Item Name: Tube Assembly

Start Date: 4/04/14 **Required Date:** 4/04/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-6D		Purchased	No			100	Each	45.0000	2	8			
AN818-6D									**		FF	14-07-10	
Nut													
				Location			**Loc Qty**		**Loc Code**				
				ST348			45						
					M126180		15			8			
					M128306		30						
M6061T6T0.375W.035		Purchased	No			100	f	102.8387	2.0833	8.77179			
M6061T6T0.375W.035									**		FF	14-07-10	
6061-T6 RD Tube .375 x.035W													
				Location			**Loc Qty**		**Loc Code**				
				MAT014			102.8387						
					112652		11			4.3850			
					124491		91.8387			4.3850			
MS20819-6D		Purchased	No			100	Each	20.0000	2	8			
MS20819-6D									**		FF	14-07-10	
Sleeve													
				Location			**Loc Qty**		**Loc Code**				
				ST312	129499		20			8			
					m128401		20						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
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☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description: Tube Assembly Work Order: 115596

Inspection Drawing: D3298 Rev: B Part Number: D3298-001

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.00	0.030	16.00	V		S Fab - 07	
3.00	0.030	3.20	V		S-Fab-00	

Measured by: FF

Date 14-07-10

Checked By: DAS 30 9-89

Date 14/07/10

QC inspector: DAS 27 9-89

Date 14/7/11

Engineering Approval (*if necessary*

Date